

5/13

DART AEROSPACE LTD	Work Order:	22513R
Description: Bracket Assembly	Part Number:	D2803-041
Dwg: D2803 Rev. B	Qty:	15 20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler Dwg not required	JA	05.02.23	20																				
2	GA	Press D2805-1 into arm as per Dwg D2803 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2803-1</td><td>Bracket</td><td>B22523A</td></tr><tr><td>1</td><td>D2805-1</td><td>Stop</td><td>B22522</td></tr><tr><td>1</td><td>D2809</td><td>Bushing</td><td>B22529</td></tr></table>	Qty	Part Number	Description	Batch	1	D2803-1	Bracket	B22523A	1	D2805-1	Stop	B22522	1	D2809	Bushing	B22529	JB	05/03/28	20				
Qty	Part Number	Description	Batch																						
1	D2803-1	Bracket	B22523A																						
1	D2805-1	Stop	B22522																						
1	D2809	Bushing	B22529																						
3	QC5	Inspect work to Step 2	Z	05.03.28	20																				
4	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	M	05.03.29	20																				
5	QC3	Inspect Powder Coat	SB	05/03/31	15																				
6	GA	Press D2809 into arm as per Dwg D2803	SB	05/03/31	15																				
7	GA	Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN3C16A</td><td>Bolt</td><td>M17185</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M17187</td></tr><tr><td>4</td><td>NAS1515H3</td><td>Washer</td><td>M17187</td></tr><tr><td>A/R</td><td>LPS-3</td><td>Corrosion Spray</td><td>M16863</td></tr></table>	Qty	Part Number	Description	Batch	2	AN3C16A	Bolt	M17185	2	MS21042L3	Nut (or -3)	M17187	4	NAS1515H3	Washer	M17187	A/R	LPS-3	Corrosion Spray	M16863	JB	05/03/31	15
Qty	Part Number	Description	Batch																						
2	AN3C16A	Bolt	M17185																						
2	MS21042L3	Nut (or -3)	M17187																						
4	NAS1515H3	Washer	M17187																						
A/R	LPS-3	Corrosion Spray	M16863																						
8	GA	Assemble as per Dwg D2803.	SB	05/03/31	15																				
9	QC5	Inspect work to Step 8	JB	05.03.31	15																				
10	ST	Identify and Stock	KD	05/03/31	15																				
11	AC	Cost / part: 75.98	545	05.04.01	15																				
12	DC	Close W/O 75.98 Inspect Level 21	JA	05.04.05	15																				

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Revise pick list	EC	
C	01.03.02	Added D2809 to pick list	EC	
D	01.04.26	Reformat	EC	
E	05.02.22	Revised Step 7	KJ/JLM	

RELEASED
05.02.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

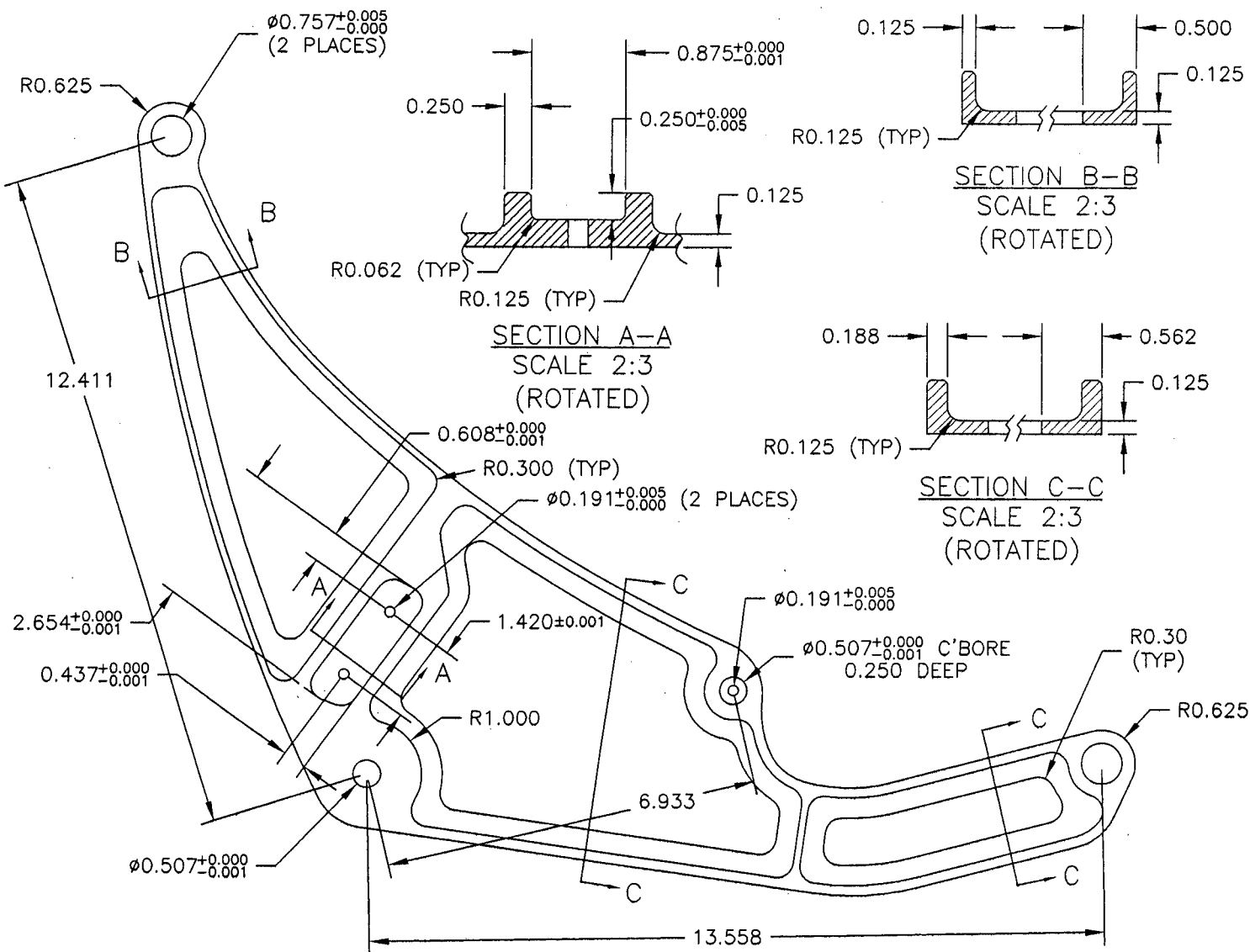
QA: N/C Closed: _____ Date: _____



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2803	REV. B
					SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			

RELEASED

05.03.11



SHOP COPY
RETURN TO
ENGINEERING

D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER

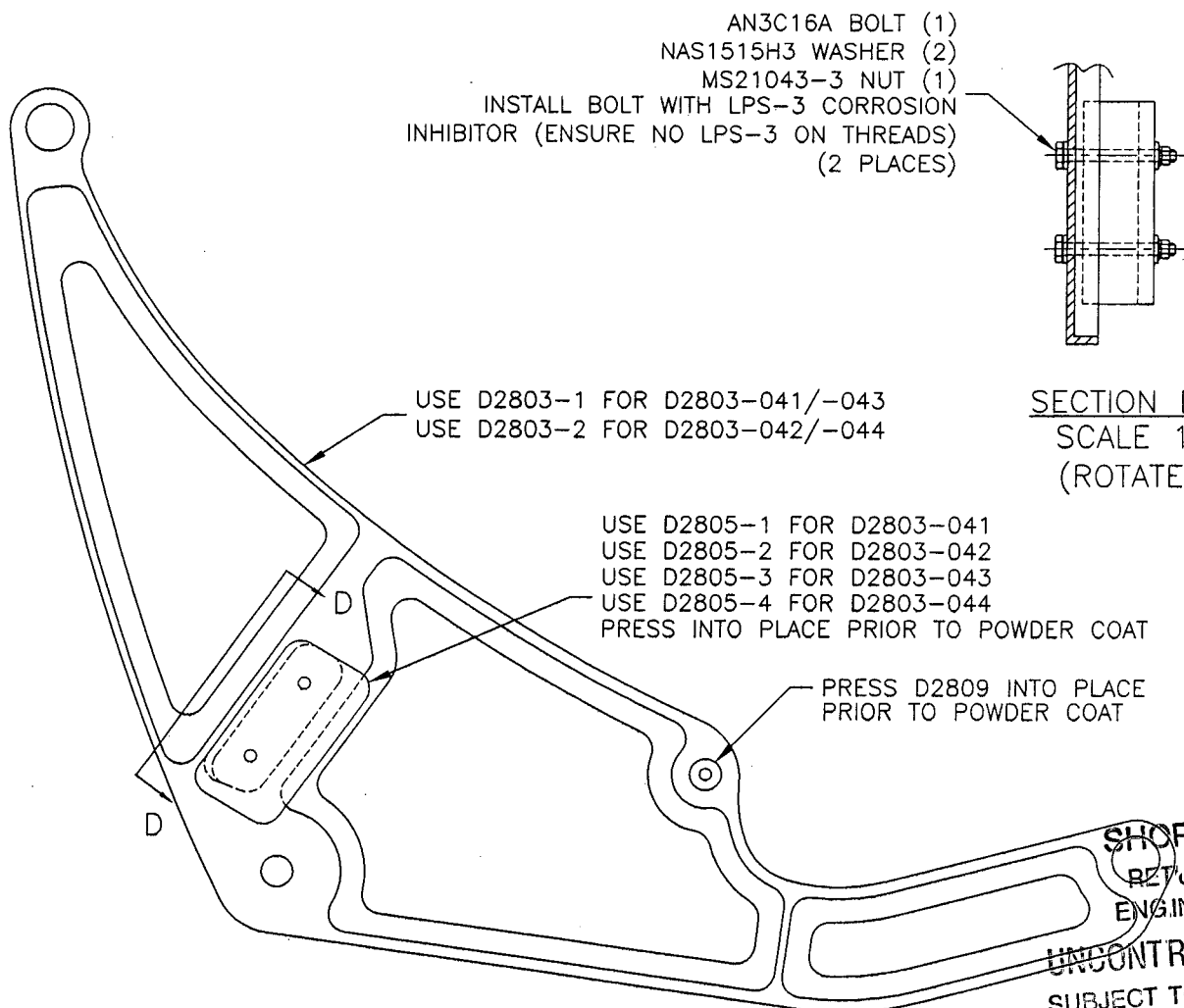
NO. 22513

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



SECTION D-D
SCALE 1:3
(ROTATED)

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WORK ORDER

RELEASED 22513

05-03.11

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 22, 2005
03:39 pm

Work Order No	: 0022513	Department Code:	
Project Name	: D2803-041	Burden Flags	: NNNNNNNN
Project For	: WK513	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2803-041	Invoice Number	:
Description	: Bracket Assembly	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 20	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 02-22-05	Actual Margin	: 0.000%
Est Finish Date	: 03-15-05		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00